

Date: Wednesday, 12/14/2005 3:57:02 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 25227	
Estimate Number : 11090	
P.O. Number : N/A	Part Number : D3243041
This Issue : 12/14/2005 S.O. No. : N/A	Drawing Number : D3243 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25117	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 12/21/2005 Qty: <u>9</u> Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est Rev:A New Issue 05-11-29 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.5774 sf(s)/Unit Total : 3.4644 sf(s)  
 Material:6061-T6 Sheet .063" Thick  
 (M6061T6S063)  
 Batch: W18556

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut Blanks:12.00" x6.600" Grain Along 12.00"

JL 05-12-20 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA385 & Dwg D3243

JL 05-12-20 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 05-12-20 10

5.0	QC8	SECOND CHECK
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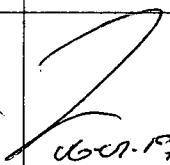


Comment: SECOND CHECK

JL 05-12-20 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
6/01/17	7	1 piece was bend over tolerance		Scrap & destroy	SB 06/01/17	 06-01-17		 06-01-17

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 05.12.05 10

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3243

SB 06/01/17 9 PTO

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.01.18 9

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:01:21 9

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part # Description Batch

4 FE-032-EF Insert M18486

SB 06/01/23 9

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D3343

SB 06/01/23 9

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.01.23 9

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Mask Holes

FC 06 01 23 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml* *2* *023* *9*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 100

*C2006101124* *9*

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 *545* *06/01/26*

*(9)*

*(9)* *06/01/25* *(9)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

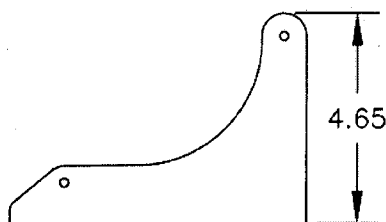
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

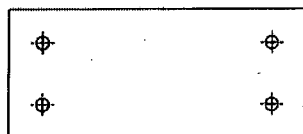




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET		SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

2.75  $\begin{smallmatrix} +0.030 \\ 0.000 \end{smallmatrix}$

GROUP 007  
REF DART  
ENG INFERIOR

UTS INTER

RELEASED  
04.02.03

8.581  
8.206  
7.706

25227

GRAIN  
DIRECTION

11.920  
11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

3.714

**D3243-041 BRACKET ASSEMBLY  
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

4.214  
R0.25 (TYP)  
3.339  
R0.38 (TYP)

5.494

R2.75  
(TYP)

D3243-1  
FLAT PATTERN

R0.50  
(TYP)

0.500  
0.000

6.560

5.810

5.360

0.750

0.500

0.000

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